

Work Order ID 84594

May-16-12 3:31:26 PM

Ship JUNE 1

84594

Page 1

Item ID: D4030-041 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Long Basket Assembly (350)
 Start Date: 16/05/2012 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 30/05/2012 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: ML5 Date: 12/05/12 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4030	C								
100	Pick Kit	0.00							
100									
Packaging	Memo	0.00							
Packaging									
110	Assemble as per dwg	0.00							
110									
HandFinish	Memo	0.00							
Hand Finishing	****Mask label plate to size of D4086 label, use scotchbrite red pad to lightly sand area for label, apply label ****								
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

6/10/31 (1)

1 φ BR 12-6-1

8/2/04/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 84594

84594

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 16/05/2012

Required Date: 30/05/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC IPP Rev:B as
per dwg revB DD 10.04.20 verified by:EC IPP Rev:C as per dwg
revC DD 10.08.18 verified by:EC IPP Rev D 12.03.27 per NCR12-
1239 EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4086-200 *D4086-200* Placard, Max Load		Manufactured	No				Each	9.0000		1			
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST093			9						
				72051			1						
				82827			8						
D2530 *D2530* Handle Weldment		Manufactured	No			100	Each	1.0000	1	1			
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST506			1						
				82895			1						
D2535 *D2535* Spring		Manufactured	No			100	Each	85.0000	2	2			
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST504			85						
				83545			85						
D2537 *D2537* Bushing		Manufactured	No			100	Each	52.0000	2	2			
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST504			52						
				82896			52						

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84594

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 16/05/2012

Required Date: 30/05/2012

Start Qty: 1.00

Required Qty: 1.00

D3913-041

Manufactured No

84594

100

Each

0.0000

1

1

**

1 ϕ BR 12-5-1

D3913-041

Long Basket Base Assembly, 350

D3914-041

Manufactured No

84594

100

Each

0.0000

1

1

**

1 ϕ BR 12-5-31

D3914-041

Long Basket Lid Assembly (350)

D3917-3

Manufactured No

100

Each

23.0000

6

6

**

D3917-3

Washer

Location

Loc Qty

Loc Code

ST070

85088

23

6

BR 12-6-1

76956

4

80598

1

81205

1

82936

17

D3953-3

Manufactured No

100

Each

29.0000

2

2

**

D3953-3

Gas Spring Stud, Lid

Location

Loc Qty

Loc Code

ST075

82939

29

29

82939

D3953-7

Manufactured No

100

Each

39.0000

2

2

**

D3953-7

Spring Spacer

Location

Loc Qty

Loc Code

ST075

82940

39

39

82940

BR 12-7-1 (1)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 16/05/2012

Required Date: 30/05/2012

Start Qty: 1.00

Required Qty: 1.00

D3953-9 Manufactured No

100 Each

48.0000

2

2

**

D3953-9

Gas Spring Washer

Location

Loc Qty

Loc Code

ST075

48

82035

8

82941

40

82035

D3953-17 Manufactured No

100 Each

33.0000

2

2

**

D3953-17

Gas Spring Spacer

Location

Loc Qty

Loc Code

ST075

33

82937

33

82937

D3953-19 Manufactured No

100 Each

43.0000

1

1

**

D3953-19

Gas Spring Bracket

Location

Loc Qty

Loc Code

ST075

43

82938

43

82938

D3953-21 Manufactured No

100 Each

8.0000

1

1

**

D3953-21

Gas Spring Bracket

Location

Loc Qty

Loc Code

ST075

8

81207

2

81456

6

81456

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Page 3

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 16/05/2012

Required Date: 30/05/2012

Start Qty: 1.00

Required Qty: 1.00

D3969-3

Manufactured No

100

Each

51.0000

1

1

**

D3969-3

Spring (Basket Lid)

Location

Loc Qty

Loc Code

ST272

51

64285

1

81887

10

82942

40

51887

AN3-14A

Purchased

No

100

Each

105.0000

4

4

**

AN3-14A

Bolt

Location

Loc Qty

Loc Code

ST352

105

121415

30

121444

25

121708

50

121415

AN3-16A

Purchased

No

100

Each

129.0000

2

2

**

AN3-16A

Bolt

Location

Loc Qty

Loc Code

ST352

129

117441

47

118628

1

120986

31

121708

50

120986

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Work Order ID: 84594

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Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 16/05/2012

Required Date: 30/05/2012

Start Qty: 1.00

Required Qty: 1.00

AN5-17A Purchased No

100 Each 104.0000 4 4

AN5-17A

Bolt

**

Location

Loc Qty

Loc Code

338	20	
121181	20	
ST338	84	
117872	34	
121541	50	

121541

AN4-12 Purchased No

100 Each 68.0000 3 3

AN4-12

Bolt

**

Location

Loc Qty

Loc Code

ST357	68	
118626	1	
119775	17	
121652	50	

119775

AN310-4 Purchased No

100 Each 53.0000 3 3

AN310-4

NUT

**

Location

Loc Qty

Loc Code

ST344	53	
120124	1	
120518	25	
121011	1	
121349	25	
121444	1	

120518

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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84594

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 16/05/2012

Required Date: 30/05/2012

Start Qty: 1.00

Required Qty: 1.00

AN310C4

Purchased

No

100

Each

53.0000

2

2

AN310C4

Nut

**

Location

Loc Qty

Loc Code

ST344

53

120360

28

121166

3

121444

22

120360

MS21042L3

Purchased

No

100

Each

2,596.000

6

6

MS21042L3

Nut

**

Location

Loc Qty

Loc Code

ST300

2596

117885

32

119017

1114

119075

138

121349

379

121444

933

121349

MS21042L5

Purchased

No

100

Each

1,529.000

4

4

MS21042L5

Nut

**

Location

Loc Qty

Loc Code

300

500

121652

500

ST300

1029

116105

5

116548

43

117611

18

119109

963

119109

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Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 16/05/2012

Required Date: 30/05/2012

Start Qty: 1.00

Required Qty: 1.00

MS24665-151

Purchased

No

100

Each

223.0000

3

3

MS24665-151

Cotter Pin

**

Q1

Location

Loc Qty

Loc Code

ST309

223

17566

223

17566
2 -

MS24665-300

Purchased

No

100

Each

163.0000

2

MS24665-300

Cotter Pin

**

a

Location

Loc Qty

Loc Code

GA

159

118234

159

118234

ST309

4

116823

4

NAS1149F0432P

Purchased

No

100

Each

960.0000

6

6

NAS1149F0432P

Washer

**

a

Location

Loc Qty

Loc Code

ST275

960

121255

2

121350

956

121350

121415

2

NAS1149F0563P

Purchased

No

100

Each

996.0000

4

4

NAS1149F0563P

Washer

**

12/2/31

Location

Loc Qty

Loc Code

ST275

996

121350

996

121350

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Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID: 84594

84594

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 16/05/2012

Required Date: 30/05/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0332P

Purchased

No

100

Each

524.0000

8

8

NAS1149F0332P

WASHER

**

12/825 3x

Location

Loc Qty

Loc Code

ST275

524

117735

13

119225

10

120986

200

121259

200

121584

50

121585

48

17317

3

12/585-5x

NAS1149C0432R

Purchased

No

100

Each

4,244.000

2

2

NAS1149C0432R

Washer

**

16/2/31

Location

Loc Qty

Loc Code

ST297

1280

117291

280

119124

1000

ST298

2964

121255

2964

12/208

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

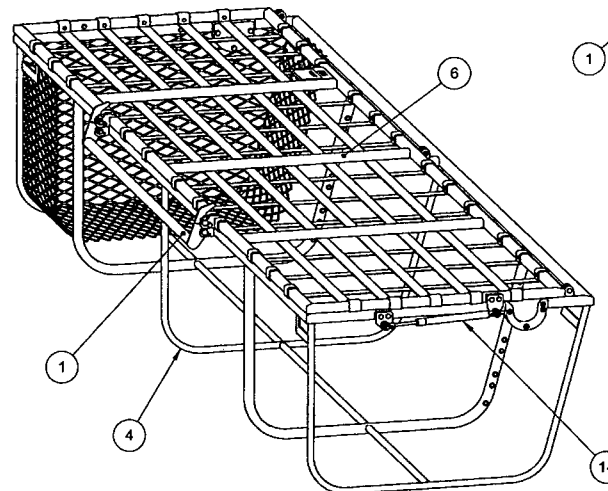
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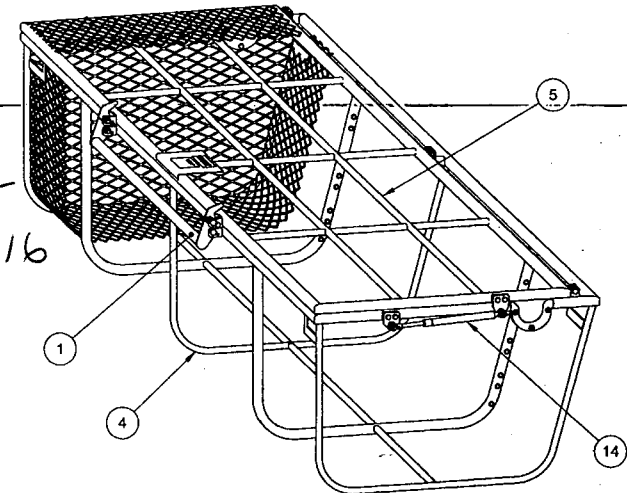
NOTE: Date & initial all entries

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4030-041	LONG BASKET ASSY (350)
		X	D4030-043	LONG BASKET ASSY, LIGHT LID (350)
1	1	1	D2530	HANDLE WELDMENT
2	2	2	D2535	SPRING
3	2	2	D2537	BUSHING
4	1	1	D3913-041	LONG BASKET BASE ASSY (350)
5	1	1	D3914-041	LONG BASKET LID ASSY (350)
6	1	1	D3915-041	LIGHT LID ASSY-LONG BASKET
7	6	6	D3917-3	WASHER
8	2	2	D3953-3	GAS SPRING STUD, LID
9	2	2	D3953-7	GAS SPRING SPACER
10	2	2	D3953-9	GAS SPRING WASHER
11	2	2	D3953-17	GAS SPRING SPACER
12	1	1	D3953-19	GAS SPRING BRACKET
13	1	1	D3953-21	GAS SPRING BRACKET
14	1	1	D3969-3	SPRING
15	4	4	AN3-14A	BOLT
16	2	2	AN3-16A	BOLT
17	2	2	AN3-20A	BOLT
18	3	3	AN4-12	BOLT (DRILLED)
19	4	2	AN5-17A	BOLT
20	2	2	AN5-21A	BOLT
21	3	3	AN310-4	NUT, CASTELLATED
22	2	2	AN310C4	NUT, CASTELLATED
23	6	6	MS21042L3	NUT
24	4	4	MS21042L5	NUT
25	3	3	MS24665-151	COTTER PIN
26	2	2	MS24665-300	COTTER PIN
27	6	6	NAS1149F0432P	WASHER
28	4	4	NAS1149F0563P	WASHER
30	8	8	NAS1149F0332P	WASHER
31	2	2	NAS1149C0432R	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 84594 MLJ
12/05/16



D4030-043 LONG BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)



D4030-041 LONG BASKET ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: -041: 72 lbs APPROX
-043: 57 lbs APPROX

RELEASED
10.08.17.07
ECN 10-996

C	QTY FOR ITEMS #30 & #31 UNDER -043 WERE MISSING (B8-1); QTY FOR ITEM #3 WAS 4 (D8-1), ONLY 2 ARE REQUIRED, AFFECTS SECTION C-C (D3-3).	MB	10.07.23
B	AN5-21A BOLT WAS AN5-19A: BOM & (D3-3)	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	ALS		
DRAWN			
CHECKED			
MFG. APPR.	JES		
APPROVED			
DE APPR.			
DATE	10.07.23		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4030** REV. C
SHEET 1 OF 3
TITLE **LONG BASKET ASSY (350)** SCALE NTS

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

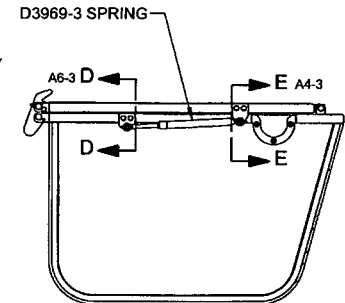
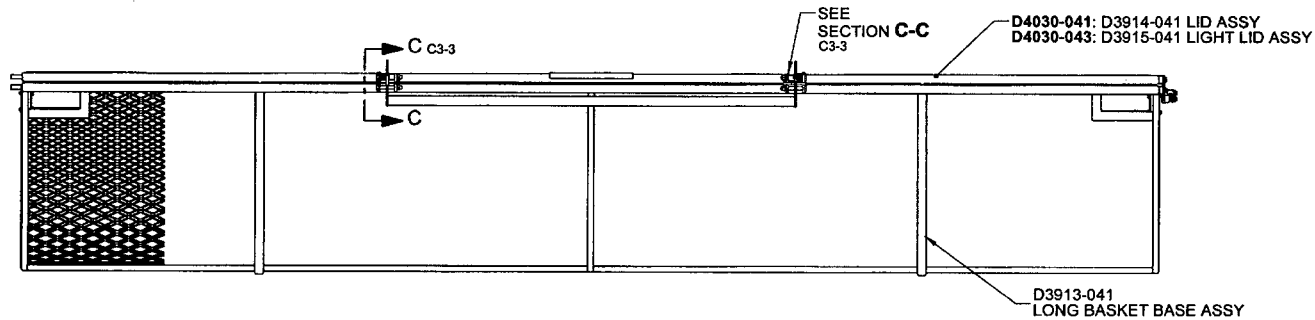
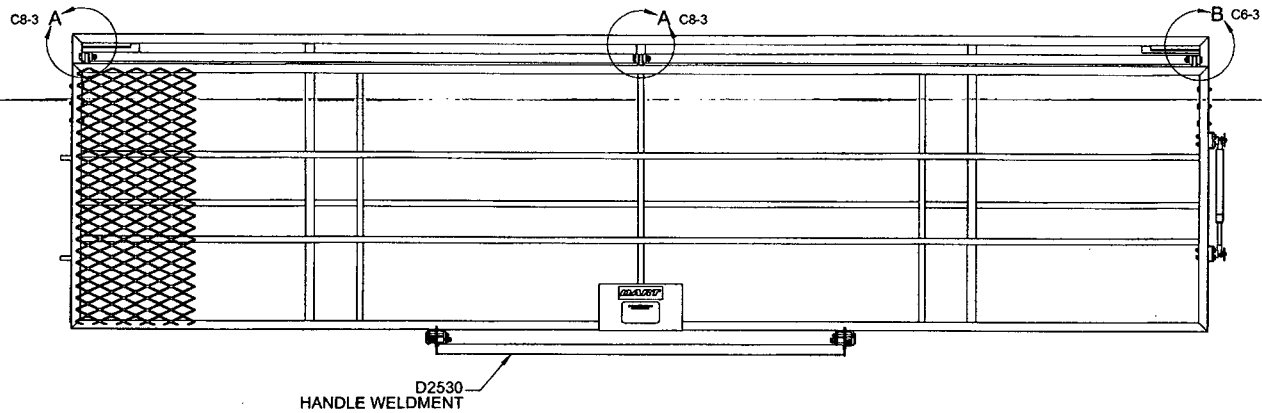
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NOTE: Date & initial all entries

04594



D4030-041 LONG BASKET ASSY (350) (SHOWN)
(MESH SHOWN LOCALLY OR REMOVED FOR CLARITY)

D4030-043 SHORT BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10.08.17 CP

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	JR	DRAWING NO.	REV. C
MFG. APPR.	SEB	D4030	SHEET 2 OF 3
APPROVED	WJL	TITLE	SCALE
DE APPR.	WJL	LONG BASKET ASSY (350)	NTS.
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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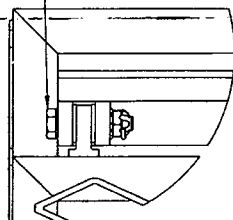
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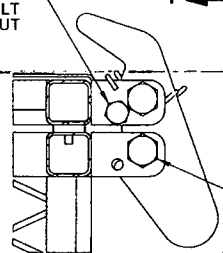
NOTE: Date & initial all entries

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



DETAIL A D8-2
D5-2

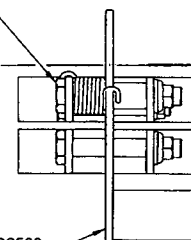
D4030-041: AN3-16A BOLT
MS21042L3 NUT
D4030-043: AN3-20A BOLT
MS21042L3 NUT



SECTION C-C B4-2
B6-2

D4030-041: AN5-17A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

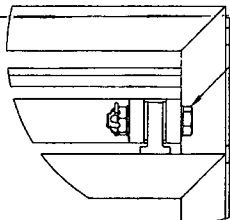
D4030-043: AN5-21A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT



VIEW F-F C3-3

D2530
HANDLE WELDMENT
REF

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



DETAIL B D3-2

D3953-17 GAS SPRING SPACER
D3953-21 GAS SPRING BRACKET
AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION D-D B2-2

D3953-17 GAS SPRING SPACER
D3953-19 GAS SPRING BRACKET
AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION E-E B1-2

RELEASED
10.08.124

DESIGN	A/S	DART AEROSPACE LTD	
DRAWN	B	HAWKESBURY, ONTARIO, CANADA	
CHECKED	J.F.S.	DRAWING NO. D4030	REV. C
MFG. APPR.	J.F.S.	TITLE	SHEET 3 OF 3
APPROVED	J.F.S.	LONG BASKET-ASSY (350)	SCALE
DE APPR.	J.F.S.		NTS
DATE	10.07.23	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries